

Work Order ID 62771

October 7, 2010 3:41:14 PM



Page 1

Item ID: D2196-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 10/07/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/14/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: C2 Date: 10/10/08 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2196	Rev C								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2196 ☒ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Deburr if necessary

B10-10-7

(3)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-10-7

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/01/08

(K3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-open hole to finish size as per dwg □ 2- deburr								
140	QC5- Inspect part completeness to step on W/O	0.00							
	QC	0.00							
QC	Memo								
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00							
	HandFinish	0.00							
Hand Finishing	Memo								

130-10-8

5.0/10/08

(X2)

BK 10-10-12

(3)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Revision ID:				Stop	
Item Name: Spacer					
Start Date: 10/07/10	Start Qty: 1.00		Cust Item ID:		
Required Date: 10/14/10	Req'd Qty: 1.00		Customer:		
Reference:					

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		=> ell	1010112	3	Ø		
170 Packaging Packaging	Identify as per dwg & Stock Location: 008 Memo	0.00 0.00							10/10/13 (3)
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							10/10/13 MF 10-10-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 62771

Parent Item: D2196-3

Parent Item Name: Spacer



Start Date: 10/07/10

Required Date: 10/14/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-07-24 new issue ec verified by:dd

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X05.00 0		Purchased	No			100	f	42.8636	0.351	0.369474	1.1		
												HB 10-10-7	
6061-T6 Bar .500 x 5.00													

HB 10-10-7

Location

Loc Qty

Loc Code

MAT03

42.8636

112041

20

112154

22.8636

112041

(3)

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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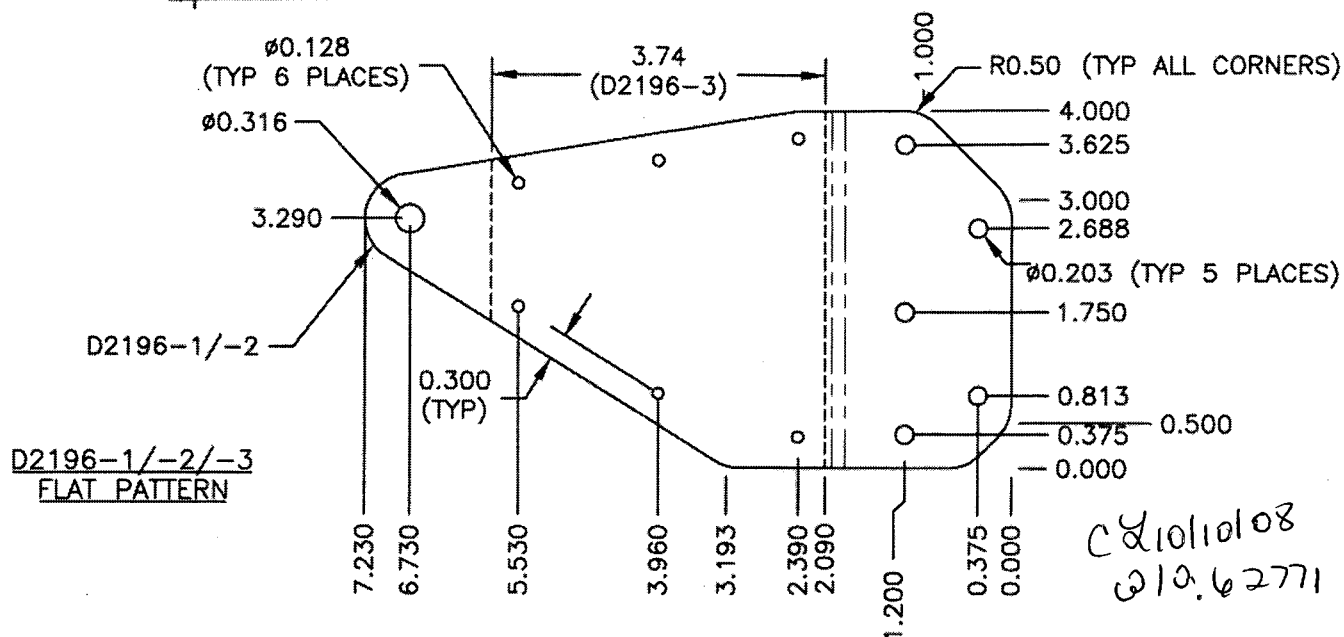
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2196	REV. C SHEET 1 OF 1
DATE 03.05.28		TITLE BRACKET	SCALE 1:2
B	93.09.23	REDESIGN	
C	03.05.28	REDRAW; D2196-3 NOW 0.5" THICK	

RELEASED
03.07.09



D2196-1/-2

- 1) MATERIAL: AISI 304/316 S.S.
0.064" THICK (M304S16GA)

D2196-3

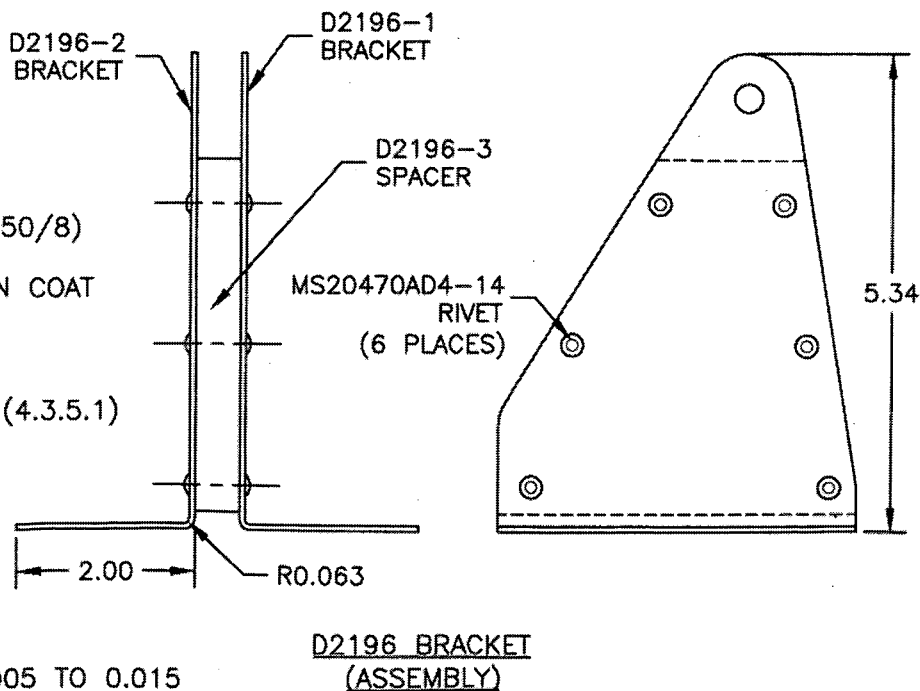
- 2) MATERIAL: 5052H32 (QQ-A-250/8)
0.500" THICK 4x0.125 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1

D2196 BRACKET (ASSEMBLY):

- 4) FINISH: POWDER COAT WHITE (4.3.5.1)
PER DART QSI 005 4.3

GENERAL NOTES:

- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.015



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